

Work Order ID 55605



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January 25, 2010 12:43:40 PM

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 1/25/10 Start Qty: 30.00



Cust Item ID:

Required Date: 2/01/10 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: *P*

Date: 10/1/25 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100	HAAS CNC VERTICAL MACHINING #1	0.00	<i>MW</i>	<i>DTP</i>	<i>10/02/01</i>	<i>10/02/02</i>	<i>30</i>	<i>Ø</i>
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HAAS 1	Memo	0.00	<i>MW</i>	<i>DTP</i>	<i>10/02/01</i>	<i>10/02/02</i>	<i>30</i>	<i>Ø</i>
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HAAS CNC vertical machine #1
 Program Batch No. 55605 Double check by: *MW* -Machine Step No 1
 per Folio FA641 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA641 and inspect p

110	QC2- Inspect parts off machine FAI/FAIB	0.00	<i>MW</i>	<i>DTP</i>	<i>10/02/01</i>	<i>10/02/02</i>	<i>30</i>	<i>Ø</i>
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QC	Memo	0.00	<i>MW</i>	<i>DTP</i>	<i>10/02/01</i>	<i>10/02/02</i>	<i>30</i>	<i>Ø</i>
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Quality Control

120	QC8- Inspect parts - second check	0.00	<i>SP</i>	<i>10/02/08</i>	<i>30</i>	<i>Ø</i>
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QC	Memo	0.00	<i>SP</i>	<i>10/02/08</i>	<i>30</i>	<i>Ø</i>
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Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55605

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Item ID: D3500-1

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 1/25/10 Start Qty: 30.00



Cust Item ID:

Required Date: 2/01/10 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

BK 10-02-8

Hand Finishing

140



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

BK 10/02/08

Powder Coating

Memo

0.00

START TIME: 11:45pm OVEN TEMPERATURE:
FINISH TIME: 320°f

150



QC

QC3- Inspect Part Finish

0.00

BK 10-02-8

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55605

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January 25, 2010 12:43:40 PM

Item ID:	D3500-1	Accept		Setup	Start		
Revision ID:						Stop	
Item Name:	Saddle						
Start Date:	1/25/10	Start Qty:	30.00		Cust Item ID:		
Required Date:	2/01/10	Req'd Qty:	30.00		Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

January 25, 2010 12:43:45 PM

Work Order ID: 55605



Parent Item: D3500-1



Parent Item Name: Saddle

Start Date: 1/25/10

Required Date: 2/01/10

Comments: IPP Rev:A New Issue 06-06-15 JLM

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	31.0000	30.0000			

Saddle Billet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	31
41962	1
46414	30

30 DJP
10/02/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	55605
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486	0.487	0.487		
B	1.175	1.185		1.178	1.176	1.178	1.178		
C	3.145	3.155		3.149	3.150	3.149	3.150		
D	1.175	1.185		1.178	1.176	1.176	1.177		
E	0.365	0.385		.382	.382	0.380	0.378		
F	0.490	0.510		.496	.498	0.499	0.498		
H									
I	R1.575	R1.595		1.590	1.591	1.5795	1.578		
J	0.240	0.260		.243	.246	0.244	0.243		
K	0.490	0.510		.497	.498	0.498	0.498		
L	3.590	3.650		3.616	3.613	3.624	3.620		
M	0.315	0.322		.317	.317	0.317	0.317		
N	0.256	0.262		.260	.260	0.260	0.260		
O	6.500	6.520		6.510	6.511	6.512	6.512		
P	5.990	6.010		5.999	6.000	6.002	6.002		
Q	2.820	2.830		2.825	2.823	2.825	2.825		
R	2.495	2.505		2.496	2.497	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.124	1.125	1.125	1.125		
U	0.540	0.560		.542	.542	0.542	0.544		
V	0.793	0.803		.797	.799	0.798	0.798		
W	R.240	R.260		Q.250	Q.250	0.250	0.250		
X	0.040	0.060		.050	.050	0.050	0.050		
Y	0.100	0.120		.105	.110	0.108	0.110		
AA	R1.125	R1.145		1.135	1.137	1.134	1.131		
AB	R.490	R.510		Q.500	Q.500	0.500	0.500		
AC	0.615	0.635		.625	.630	0.635	0.635		
AD	0.240	0.260		.253	.253	0.255	0.252		
AE	1.810	1.830		1.821	1.810	1.816	1.816		
AF	0.240	0.260		.248	.248	0.246	0.246		
AG	0.140	0.160		.150	.149	0.145	0.145		
AH	0.140	0.160		.151	.151	0.150	0.150		
AI	0.140	0.160		.152	.153	0.160	0.151		
Accept/Reject									

Measured by:	NMJ	/ DJP	Audited by:	SP
Date:	10/02/01	10/02/02	Date:	10/02/04

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	JK

DART AEROSPACE LTD				Work Order:	55605
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.483	0.490		0.487	0.487	0.487	.487		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		0.379	0.378	0.380	0.377		
F	0.490	0.510		0.495	0.496	0.4955	0.495		
H									
I	R1.575	R1.595		1.5785	1.584	1.5805	1.5815		
J	0.240	0.260		0.242	0.242	0.242	0.242		
K	0.490	0.510		0.498	0.500	0.4995	0.499		
L	3.590	3.650		3.624	3.620	3.617	3.615		
M	0.315	0.322		0.317	0.317	0.317	.317		
N	0.256	0.262		0.259	0.259	0.259	.259		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.002	6.002	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.545	0.543	0.547	0.546		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.110	0.110	0.110		
AA	R1.125	R1.145		1.134	1.140	1.1365	1.1355		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.252	0.252	0.252	0.251		
AE	1.810	1.830		1.819	1.823	1.821	1.818		
AF	0.240	0.260		0.248	0.252	0.2505	0.249		
AG	0.140	0.160		0.149	0.153	0.152	0.150		
AH	0.140	0.160		0.148	0.148	0.145	0.145		
AI	0.140	0.160		0.150	0.148	0.145	0.147		
Accept/Reject									

Measured by:	DP	Audited by:	JP
Date:	10/02/02	Date:	10/02/02

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	JK

DART AEROSPACE LTD				Work Order: 55605	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12	By	Date
A	0.483	0.490		.487	0.487	0.487	0.487		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		0.380	0.380	0.380	0.380		
F	0.490	0.510		0.495	0.495	0.496	0.496		
H									
I	R1.575	R1.595		1.580	1.579	1.580	1.580		
J	0.240	0.260		0.242	0.242	0.242	0.243		
K	0.490	0.510		0.499	0.498	0.498	0.499		
L	3.590	3.650		3.620	3.620	3.620	3.62		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.510	6.511	6.512	6.512		
P	5.990	6.010		6.000	6.001	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.548	0.547	0.547	0.547		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		0.250	.250	.250	.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.135	1.137	1.137	1.137		
AB	R.490	R.510		0.500	.500	.500	.500		
AC	0.615	0.635		0.635	.635	.635	.635		
AD	0.240	0.260		0.251	0.253	0.252	0.253		
AE	1.810	1.830		1.821	1.8215	1.820	1.8215		
AF	0.240	0.260		0.250	0.250	0.250	0.250		
AG	0.140	0.160		0.151	0.151	0.151	0.151		
AH	0.140	0.160		0.151	0.148	0.150	0.150		
AI	0.140	0.160		0.148	0.152	0.152	0.154		
Accept/Reject									

Measured by:	<i>KJ/EC</i>	Audited by:	<i>KJ</i>
Date:	<i>10/02/02</i>	Date:	<i>10/02/02</i>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC <i>KJ</i>	<i>DS</i>

DART AEROSPACE LTD				Work Order:	55605
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
A	0.483	0.490		0.487	0.487	0.487	0.487		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		0.380	0.380	0.380	0.380		
F	0.490	0.510		0.498	0.496	0.496	0.496		
H									
I	R1.575	R1.595		1.580	1.581	1.585	1.5785		
J	0.240	0.260		0.243	0.243	0.243	0.243		
K	0.490	0.510		0.499	0.499	0.499	0.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.317	0.317	0.317	.317		
N	0.256	0.262		0.259	0.259	0.259	.259		
O	6.500	6.520		6.510	6.511	6.511	6.511		
P	5.990	6.010		6.000	6.001	6.001	6.001		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.547	0.547	0.547	0.547		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.1355	1.1362	1.140	1.137		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.254	0.253	0.252	0.252		
AE	1.810	1.830		1.8215	1.821	1.822	1.820		
AF	0.240	0.260		0.250	0.250	0.251	0.249		
AG	0.140	0.160		0.151	0.151	0.152	0.150		
AH	0.140	0.160		0.150	0.150	0.148	0.150		
AI	0.140	0.160		0.153	0.153	0.153	0.153		
Accept/Reject									

Measured by:	<i>DJP</i>	Audited by:	<i>AS</i>
Date:	10/02/02	Date:	10/02/02

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC <i>AS</i>	<i>AS</i>

DART AEROSPACE LTD				Work Order:	55605
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20	By	Date
A	0.483	0.490		0.487	.487	0.487	0.487		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		0.380	0.377	0.377	0.380		
F	0.490	0.510		0.498	0.496	0.497	0.496		
H									
I	R1.575	R1.595		1.5805	1.585	1.583	1.580		
J	0.240	0.260		0.242	0.243	0.243	0.243		
K	0.490	0.510		0.499	0.499	0.499	0.499		
L	3.590	3.650		3.620	3.62	3.622	3.625		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.259	.259	0.259	0.259		
O	6.500	6.520		6.511	6.511	6.512	6.512		
P	5.990	6.010		6.001	6.001	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.546	0.546	0.546	0.546		
V	0.793	0.803		0.798	0.798	.798	.798		
W	R.240	R.260		0.250	0.250	.250	.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.135	1.1385	1.136	1.136		
AB	R.490	R.510		0.500	0.500	.500	.500		
AC	0.615	0.635		0.635	0.635	.635	.635		
AD	0.240	0.260		0.252	0.251	0.251	0.251		
AE	1.810	1.830		1.820	1.823	1.820	1.820		
AF	0.240	0.260		0.249	0.252	0.249	0.249		
AG	0.140	0.160		0.149	0.153	0.150	0.150		
AH	0.140	0.160		0.148	0.148	0.148	0.147		
AI	0.140	0.160		0.150	0.150	0.149	0.152		
Accept/Reject									

Measured by:	<i>DJP</i>	Audited by:	<i>JK</i>
Date:	10/02/03	Date:	10/04/04

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	<i>JK</i> <i>AS</i>

DART AEROSPACE LTD				Work Order:	55605
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		0.487	0.487	0.487	0.487		
B	1.175	1.185		1.180	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.179	1.179	1.179		
E	0.365	0.385		0.379	0.378	0.380	0.380		
F	0.490	0.510		0.495	0.494	0.496	0.496		
H									
I	R1.575	R1.595		1.579	1.5855	1.583	1.590		
J	0.240	0.260		0.242	0.242	0.243	0.241		
K	0.490	0.510		0.499	0.499	0.499	0.499		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.259	0.259	0.259	0.259		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.002	6.002	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.546	0.546	0.546	0.547		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.134	1.1355	1.1345	1.138		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.252	0.252	0.252	0.251		
AE	1.810	1.830		1.819	1.819	1.819	1.819		
AF	0.240	0.260		0.248	0.248	0.248	0.249		
AG	0.140	0.160		0.149	0.149	0.149	0.150		
AH	0.140	0.160		0.149	0.149	0.149	0.148		
AI	0.140	0.160		0.152	0.150	0.152	0.153		
Accept/Reject									

Measured by:	DTP	Audited by:	BB
Date:	10/02/03	Date:	10/02/03

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	MM

DART AEROSPACE LTD				Work Order:	55605
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	25	26	27	28	By	Date
A	0.483	0.490		0.487	0.487	0.487	0.487		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		0.380	0.380	0.380	0.380		
F	0.490	0.510		0.4940	0.4946	0.498	0.498		
H									
I	R1.575	R1.595		1.586	1.582	1.5805	1.582		
J	0.240	0.260		0.242	0.241	0.2415	0.241		
K	0.490	0.510		0.499	0.499	0.499	0.499		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.259	0.259	.259	0.259		
O	6.500	6.520		6.510	6.510	6.511	6.511		
P	5.990	6.010		6.000	6.000	6.001	6.001		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.547	0.547	0.547	0.547		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.137	1.135	1.134	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.251	0.251	0.251	0.251		
AE	1.810	1.830		1.823	1.819	1.819	1.8195		
AF	0.240	0.260		0.250	0.249	0.248	0.248		
AG	0.140	0.160		0.153	0.149	0.149	0.149		
AH	0.140	0.160		0.148	0.150	0.150	0.150		
AI	0.140	0.160		0.150	0.152	0.152	0.151		
Accept/Reject									

Measured by:	<i>DJD</i>	Audited by:	<i>SD</i>
Date:	<i>10/02/06</i>	Date:	<i>10/02/06</i>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	<i>JK</i> <i>AS</i>

DART AEROSPACE LTD				Work Order: 55605	
Description: Saddle			Part Number: D3500-1		
Inspection Dwg: D3500 Rev: C			Page 1 of 1		

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	29	30	3	4	By	Date
A	0.483	0.490		0.487	0.487				
B	1.175	1.185		1.179	1.179				
C	3.145	3.155		3.150	3.150				
D	1.175	1.185		1.179	1.179				
E	0.365	0.385		0.380	0.380				
F	0.490	0.510		0.4965	0.497				
H									
I	R1.575	R1.595		1.584	1.584				
J	0.240	0.260		0.243	0.243				
K	0.490	0.510		0.499	0.499				
L	3.590	3.650		3.625	3.625				
M	0.315	0.322		0.317	0.317				
N	0.256	0.262		0.259	0.259				
O	6.500	6.520		6.511	6.511				
P	5.990	6.010		6.001	6.001				
Q	2.820	2.830		2.825	2.825				
R	2.495	2.505		2.500	2.500				
S	2.245	2.255		2.250	2.250				
T	1.120	1.130		1.125	1.125				
U	0.540	0.560		0.547	0.547				
V	0.793	0.803		0.798	0.798				
W	R.240	R.260		0.250	0.250				
X	0.040	0.060		0.050	0.050				
Y	0.100	0.120		0.110	0.110				
AA	R1.125	R1.145		1.137	1.1365				
AB	R.490	R.510		0.500	0.500				
AC	0.615	0.635		0.635	0.635				
AD	0.240	0.260		0.252	0.252				
AE	1.810	1.830		1.819	1.819				
AF	0.240	0.260		0.249	0.249				
AG	0.140	0.160		0.150	0.150				
AH	0.140	0.160		0.149	0.148				
AI	0.140	0.160		0.149	0.149				
Accept/Reject									

Measured by:	<i>DIP</i>	Audited by:	<i>SD</i>
Date:	<i>10/02/08</i>	Date:	<i>10/02/08</i>

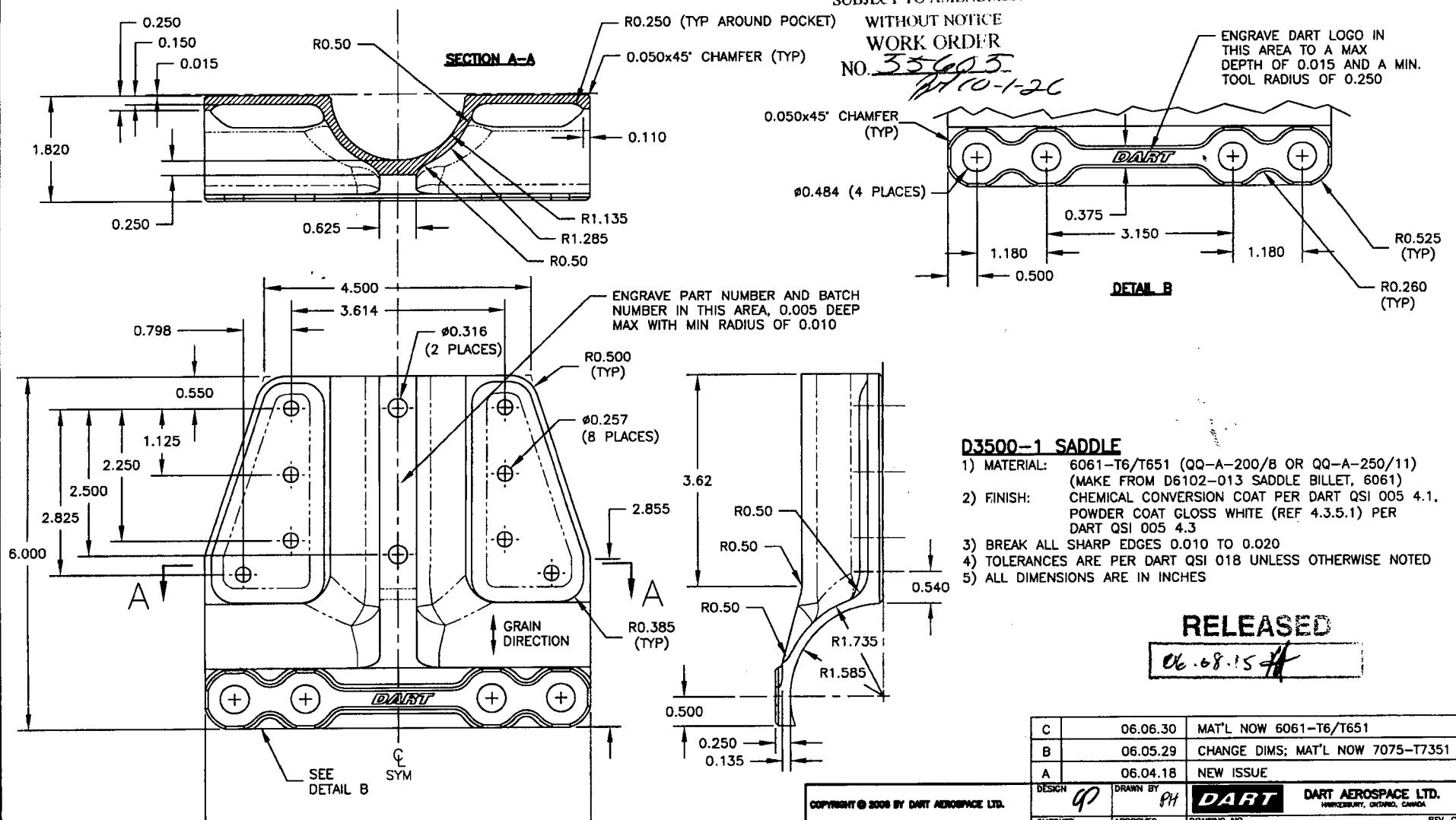
Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC <i>dk</i>	<i>DS</i>

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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 3500-1-2C



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11)
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15 #

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	GP	DRAWN BY PH DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	#	APPROVED # DRAWING NO. D3500 REV. C
DATE	06.06.30	TITLE SCALE SADDLE 2:3

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